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(54) Processes for the preparation of saturated alcohol derivatives and their use in detergent plasticizer and synthetic lubricant formulations.

(57) This invention relates to processes for making biodegradable surfactant. The process comprises several steps including an optional step. The first step is directed to reacting olefins with ZSM-23 catalyst to form oligomers having the formula  $(C_3)_x$ ,  $(C_4)_x$  or mixtures thereof. Second, the oligomer is hydroformylated to form a saturated alcohol, for example, tridecanol. Next, the saturated alcohol is ethoxylated. Thereafter a nonionic biodegradable surfactant is recovered. This surfactant can be used in detergent formulations. A process is also taught for making esters which can be used as lubricants or plasticizers. A specific hydroformylation process is taught which utilizes modified cobalt carbonyl catalyst. Also, a specific ethoxylation process is taught. Products formed according to the latter two processes as well as their uses are also taught.

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# PROCESSES FOR THE PREPARATION OF SATURATED ALCOHOL DERIVATIVES AND THEIR USE IN DETERGENT; PLASTICIZER; AND SYNTHETIC LUBRICANT FORMULATIONS

THIS INVENTION relates to processes for the preparation of saturated alcohol derivatives and their use in detergent; plasticizer; and synthetic lubricant formulations. More particularly, this invention relates to the preparation of nonionic tridecanol-ethoxylates and anionic tridecanol-ethoxylate sulphates.

According to one aspect of this invention, there is provided a process for the preparation of a saturated alcohol derivatives, which process comprises:

- (a) reacting propylene and/or a butylene over ZSM-23, as catalyst, to form an oligomer;
- (b) hydroformylating the oligomer to form a saturated alcohol; and
- (c) ethoxylating or esterifying the saturated alcohol.

This invention also provides a process for the preparation of an ester of such an ethoxylated saturated alcohol, which process further comprises a process for the preparation of an ester of the ethoxylated saturated alcohol defined above, which process further comprises:

- (d) sulphonating the ethoxylated saturated alcohol.

ZSM-23 is a medium pore zeolite the crystalline structure of which has a characteristic X-ray diffraction pattern which is disclosed in U.S. Patent No. 4,076,842. The shape-selective oligomerization polymerization ZSM-23 catalysts preferred for use herein include crystalline aluminosilicate zeolites having a silica-to-alumina molar ratio of at least 12, a constraint index from 8 to 10, and acid cracking activity (alpha value) from 10 to 300. A suitable shape selective medium pore catalyst for fixed bed is a small crystal H-ZSM-23 zeolite having alpha value of about 25, with alumina binder in the form of cylindrical extrudates from 1 to 5 mm. The preferred catalyst consists essentially of ZSM-23 having a crystallite size from 0.02 to 2 microns, with framework metal synthesized as gallo-silicate, ferrosilicate, and/or aluminosilicate. These zeolites have a pore size of 4.5 x 5.6 Angstroms, such as to freely sorb normal hexane. In addition, the structure must provide constrained access to larger molecules.

It is generally understood that the proportion of internal acid sites relative to external acid sites increases with larger crystal size. However, the smaller crystallites, usually less than 0.1 micron, are preferred for diffusion-controlled reactions, such as oligomerization and polymerization. Accordingly, it may be required to neutralize more than 15% of the total Bronsted acid sites by chemisorption of a basic deactivating agent.

The degree of steric hindrance should also be considered in the choice of the basic nitrogen compounds, especially the bulky trialkyl pyridine species having alkyl groups of 1 to 4 carbon atoms. Although the selected organonitrogen compound must be bulky enough to prevent infusion of said compound into the internal pores of the catalyst, excessive steric hindrance may prevent effective or complete interaction between the surface Bronsted acid site and the selected basic species.

Catalysts of low surface activity can be obtained by using medium pore, shape selective ZSM-23 zeolites of small crystal size that have been deactivated by one or more trialkyl pyridine compounds, such as 2,4,6-collidine (2,4,6-trimethyl pyridine, gamma-collidine). These compounds all must have a minimum cross-section diameter greater than the effective pore size of the zeolite to be treated; that is, greater than 5 Angstroms.

When propylene or butene are oligomerized according to processes described herein, a unique mixture of liquid hydrocarbon products is formed. More particularly, this mixture of hydrocarbons may comprise at least 95% by weight of mono-olefin oligomers of the empirical formula:



wherein: n is from 3 to 4; and

m is greater than 1 to approximately 10.

Desirably, the mono-olefin oligomers comprise at least 20% by weight of olefins having at least 12 carbon atoms, the olefins having at least 12 carbon atoms having an average of from 0.80 to 2.00, preferably less than 1.4, methyl side groups per carbon chain, the olefins not having any side groups other than methyl.

It will be understood that methyl side groups are methyl groups which occupy positions other than the terminal positions of the first and last (i.e., alpha and omega) carbon atoms of the longest carbon chain. This longest carbon chain is also referred to herein as the straight backbone chain of the olefin. The average number of methyl side groups for the C<sub>12</sub> olefins may comprise any range with the range of 0.80 to 2.00, for example, from 0.80 to 1.90; from 0.80 to 1.80; from 0.80 to 1.70; from 0.80 to 1.60; from 0.80 to 1.50; from 0.80 to 1.40; and from 0.80 to 1.30.

As an example of branching, the dodecene fraction prepared from propylene and ZSM-23 [ZSM23-

$C_3/C_4$

branching

dodecenes] typically has 1.3 methyl branches. This can be reduced to 1.0 or less by varying reaction conditions. This compares favorably with dodecenes prepared from propylene and conventional Bronsted or Lewis acids which typically have greater than 3.0 methyl branches.

These oligomers may be separated into fractions by conventional distillation separation. When propylene is oligomerized, olefin fractions containing the following numbers of carbon atoms can be obtained: 6, 9, 12, 15, 18 and 21. When butene is oligomerized, olefin fractions containing the following numbers of carbon atoms may be obtained: 8, 12, 16, 20, 24 and 28. It is also possible to oligomerize a mixture of propylene and butene and to obtain a mixture of oligomers having at least 6 carbon atoms.

One use of olefin oligomers described herein, particularly  $C_{12} +$  fractions, is an detergent alcohols. The lower carbon number fractions, particularly  $C_6$ - $C_{12}$ , making good intermediates for making plasticizer alcohols. The projected low cost of the ZSM23-olefins, which arises from using a refinery propylene/propane stream as their starting material, makes them economically attractive. Thus, the combination of cost and structure make ZSM23-olefins possible starting materials for biodegradable surfactant alcohols and high performance plasticizer and lubricant alcohols.

Hydroformylation, a rhodium or cobalt catalyzed addition of carbon monoxide and hydrogen gas to an olefin, typically produces aldehydes. However, Slauch and Mullineaux discovered that hydroformylations using complexes of tri-n-butylphosphine and cobalt carbonyl catalyze the conversion of olefins directly to alcohols (i.e., the initially formed aldehydes concurrently hydrogenate). Also, the new primary alcohol function ( $-CH_2-OH$ ) bonds predominately on the carbon chain-end. This permits using a variety of internal olefins as feeds, because they isomerize to a terminal position before hydroformylating. Chain-end hydroformylation maintains alcohol linearity which applicants have discovered is important for making biodegradable surfactants. In contrast, rhodium-based catalysts do not promote olefin isomerization, and hydroformylation occurs predominately on the original double bond.

In accordance with the invention, the hydroformylation is suitably effected with a catalyst comprising a phosphine ligand and at a temperature sufficient to promote the formation of the alcohol while retarding formation of the paraffin. Preferably, the phosphine ligand comprises tributylphosphine or a substituted or unsubstituted phenylphosphabicyclononane; for example, a 9-phenyl-9-phosphabicyclo [4.2.1] nonane, 9-phenyl-9-phosphabicyclo [3.3.1] nonane or a 2,2,6,6-tetramethyl-1-phenylphosphabicyclononane.

The hydroformylation is preferably effected at a temperature less than  $160^\circ\text{C}$ , preferably less than  $135^\circ\text{C}$ .

The alcohol so produced preferably comprises a  $C_{10}$  to  $C_{16}$  alcohol, especially tridecanol. This alcohol may then be ethoxylated in known manner, for example with theylene oxide with an alkali metal alkoxide as catalyst or esterified to form a carboxylate or sulphate. Preferred esters, as lubricants, are adipates which may have a viscosity index of about 159 and phthalates, as plasticizers, which may have a pour point of about  $-54^\circ\text{C}$ .

In accordance with further aspects, this invention provides a detergent which comprises, as biodegradable surfactant,, a nonionic  $C_{10}$  to  $C_{16}$ , preferably  $C_{13}$ , alcohol ethoxylate or sulphate or an anionic  $C_{10}$  to  $C_{16}$ , preferably  $C_{13}$ , alcohol ethoxylate sulphate as herein prepared, or a salt thereof. This invention also provides a plasticizer and a synthetic lubricant comprising an ester as herein prepared.

This invention further provides the use, as a surfactant lubricant or plasticizer, of a saturated alcohol derivative wherein the saturated alcohol is prepared by reacting propylene and/or a butylene over ZSM-23 to form an oligomer; and hydroformylating the oligomer.

This invention is further illustrated, by way of example, with reference to the accompanying drawings in which:

- Fig. 1 shows yields for tridecanol preparation by hydroformylation with ZSM23-dodecenes;
- Fig. 2 shows promotion of CO insertion and alcohol synthesis;
- Fig. 3 depicts mechanisms for paraffin formulation;
- Fig. 4 depicts GLPC's of two alcohol-ethoxylates as either acetate esters;
- Fig. 5 summarizes soil removal data for phosphorus built liquid;
- Fig. 6 summarizes soil removal data for inbuilt liquid;
- Fig. 7 shows biodegradation data; and
- Fig. 8 shows absolute tridecanol biodegradation.

The following Examples illustrate the invention.

#### EXAMPLE 1

Hydroformylation  
(oxonation)

ethanification  
esterification

plasticizer,  
synthetic  
lubricant

Temperature, Pressure, and Catalyst Effects on Tridecanol Yield.

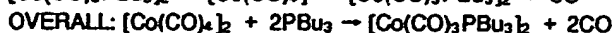
Using 2-level factorial designed experiments, applicants hydroformylate ZSM23-dodecenes and measure tridecanol yield while varying temperature (140° to 180° C), pressure (200 or 1000 psig), and catalyst which is either a mixture of octacarbonyldicobalt and tri-n-butylphosphine or  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$ . In the factorial design, applicants incorporate both mid-point experiments (160° C, 600 psig, using both catalysts), and subsequently, a star-point experiment (200° C, 1000 psig, using  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$  as catalyst). The ZSM23-dodecenes had 1.3 methyl branches on average, a calculated number based on analysis which showed 7% normal dodecenes, 69% monomethyldodecenes, and 24% polymethylated-dodecenes which are assumed to have 2.5 branching methyl groups. Several reaction variables are held constant including mole ratio of hydrogen gas to carbon monoxide at 2:1, dodecene to cobalt mole ratio at 80:1, and use of fresh catalyst for each batch with no recycle. Figure 1 and Table 1 collect the tridecanol yields which vary from 24 to 70% depending on conditions. The results are

- 1) Increasing temperature increases yield until leveling off at 180° + -20° C.
- 2) Pressure between 200 and 1000 psig of the hydroformylating gas ( $\text{H}_2$  CO mixture) has negligible effect on yield.
- 3) As a hydroformylation catalyst, the physical mixture of  $[\text{Co}(\text{CO})_4]_2$  and  $\text{PBU}_3$  is inferior to  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$ .

Increasing temperature reportedly accelerates two side reactions, olefin hydrogenation and catalyst decomposition. At 180° + -20° C, the desired alcohol producing reaction maximizes.

The relatively flat yield response to pressure changes follows the trend Slauch and Mullineaux observed. The upper and lower faces in Figure 1 have average yields of 49 and 47%, respectively. However, within this relatively flat yield response, changing pressure causes two small but observable trends. With  $[\text{Co}(\text{CO})_4]_2$  and  $\text{PBU}_3$  as the catalyst precursors, yields decrease (29 to 24% and 50 to 41%) when going to higher pressure. With  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$  as catalyst precursor, yields increase (44 to 60% and 63 to 69%) when going to higher pressure. In the former, increasing pressure increases carbon monoxide concentration which presumably pushes equilibria away from  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$ , the precursor which hydrogenates to active catalyst. In the latter, increasing pressure also increases hydrogen gas concentration which presumably increases hydrogenation of  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$  to active catalyst. Thus, depending upon catalyst precursor selection, changing pressure will cause small yield changes.

Compared to  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$ , the mixture of  $[\text{Co}(\text{CO})_4]_2$  and  $\text{PBU}_3$  is inferior as catalyst. The experiments on the front face of Figure 1 used the catalyst mixture and have an average yield of 36% compared to 59% for the rear.  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$  must be synthesized. Applications hypothesize that  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$  is an intermediate along the path to the active catalyst  $\text{HCo}(\text{CO})_3\text{PBU}_3$ , an observable species, and  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$  forms in an equilibrium controlled reaction involving  $[\text{Co}(\text{CO})_4]_2$ ,  $\text{PBU}_3$ , and carbon monoxide. See, van Boven, M., Alemdaroglu, N.H., Penninger, J.M.L., Hydroformylation with Cobalt Carbonyl and Cobalt Carbonyl-Tributylphosphine Catalysts, Ind. Eng. Chem. Prod. Res. Develop., 14(4), 259-264 (1975); Whyman, R., In Situ Infrared Spectral Studies on The Cobalt Carbonyl-Catalyzed Hydroformylation of Olefins, 66, C23-C25 (1974), all references hereby incorporated by reference. Thus, the PRESENCE of carbon monoxide inhibits its formation:



Testing that hypothesis, applicants heat a mixture of  $[\text{Co}(\text{CO})_4]_2$ ,  $\text{PBU}_3$ , and ZSM23-dodecenes at 110° C and atmospheric pressure in the absence of carbon monoxide. Applicants monitor reaction progress by infrared spectroscopy because the first-formed product, the salt  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2^+ [\text{Co}(\text{CO})_4]^-$ , has two intense absorption maxima at 1997 and 1885  $\text{cm}^{-1}$ , and  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$  has a single, strong absorption maxima at 1950  $\text{cm}^{-1}$ . See Mirbach, M.F., Mirbach, M.J., Wegman, R.W., Photochemical Ligand Dissociation, Electron Transfer and Metal-Metal Bond Cleavage of Phosphine-Substituted Cobalt Carbonyl Complexes, Organometallics, 3, 900-903 (1984), hereby incorporated by reference. After one hour, the reaction solution contains only  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$

To determine optimal tridecanol synthesis, applicants charge an autoclave with  $[\text{Co}(\text{CO})_4]_2$ ,  $\text{PBU}_3$ , and ZSM23-dodecenes, and heated it at 100° C and atmospheric pressure for one hour. Then, the autoclave is pressured to 1000 psig with a hydrogen gas-carbon monoxide mixture and heated at 175° -180° C. Vacuum distillation (the usual isolation procedure) gave tridecanol in 61% yield. This compares favorably to the 41% yield obtained without pre-reaction heating (compare references 12 and 10 in Table 1), and suggests that this two-component catalyst may give yields approaching 70%, the yield achieved using  $[\text{Co}(\text{CO})_3\text{PBU}_3]_2$ .

Characterization of Tridecanols.

The proton-NMR derived branching index, defined as the ratio of integrals for all methyl protons to all protons expressed as a percent, indicates that these tridecanols had 1.4 branching methyl groups, nearly the same number of branching methyl groups in the ZSM23-dodecene feed. See Agrawal, K.M., Joshi, G.C., Microcrystalline Waxes. 1. Investigations on the Structure of Waxes by Proton Nuclear Magnetic Resonance Spectroscopy, 31, 693 (1981), hereby incorporated by reference. This implies that hydroformylation created carbon-carbon bonds on methyl groups only, because no new branches are created. Id. For method to calculate the number of branching methyl groups from the branching index. Table 2 collects physical and spectroscopic data on ZSM23-tridecanol.

Characterization of Recovered C<sub>12</sub>'s.

Not surprisingly, the cobaltcarbonylphosphine catalyst, which readily hydrogenates aldehydes to alcohols, also hydrogenates olefins to undesired paraffins. According to Slauch and Mullineaux, paraffin formation, which typically averages 10-20%, increases with increasing reaction temperature and olefin branching. In an extreme case, hydroformylation of isobutylene gave 43% of isobutane. Applicants analyzed the recovered C<sub>12</sub> fraction from the 70% tridecanol yield hydroformylation (reference 11 in Table 1) looking for olefins and paraffins; this data aids in determining whether tridecanol yield can exceed 70%.

Proton NMR, <sup>13</sup>C NMR, and bromine number determinations establish that the recovered C<sub>12</sub> fraction contained greater than 95% paraffin and less than 5% olefin. Two methods, infrared spectroscopy and GLPC analyses, failed. Presumably, this dilute olefin mixture of multiple isomers, each having relatively weak absorbances (C=C stretch, =C-H bending for tri-substituted olefins), kept the signal buried in the spectra's baseline. GLPC failed because of the mixture's complexity even when starting with a sub-ambient temperature program on a 50 meter capillary column.

The relatively high paraffin yield from these reactions (approx. 25%) indicates that tri-substituted double bonds, or di-substituted olefins that isomerize to tri-substituted olefins, readily hydrogenate. Assuming a methyl group is one of three substituents on these tri-substituted olefins, double bond isomerization toward the methyl carbon and addition of cobalt hydride (the active catalyst) would give an intermediate structurally similar to that formed during hydroformylation of isobutylene. Like isobutylene, the relatively high paraffin content probably results from structural features of these methyl-branched ZSM23-olefins.

Hydroformylating ZSM23-dodecene with phosphine modified cobalt carbonyl catalyst, gives tridecanol in approximately 70% yield. The balance is mostly paraffins formed by olefin hydrogenation.

ExperimentalInstrumentation:

Infrared spectra are recorded on a Perkin-Elmer 283 infrared spectrometer using a 3 minute scan. NMR spectra are recorded on a JEOL FX90Q using deuteriochloroform as solvent and tetramethylsilane as an internal standard for proton spectra. GLPC is done on a Shimadzu GC-9A fitted with a 50 meter by 0.32 mm ID WCOT fused silica column coated with CP-SL 5CB. Flow rate is 1.8 cm/sec at 0.4 bar inlet pressure. Initial temperature is 60°C (except for the sub-ambient runs at -15°C) which is held for 12 min and then heated at 15°C/min until reaching 255°C where it is maintained for 41 minutes. Injection port is maintained at 300°C. Detector is a FID.

Raw Materials:

ZSM23-dodecenes are used as received. The dodecenes having 1.3 methyl branches per C<sub>12</sub> consisted of 85% C<sub>12</sub>, 5% C<sub>11</sub>-, and 10% C<sub>13</sub>+. The 2:1 volume mixture of hydrogen gas and carbon monoxide are both CP grade. Aldrich Chemical Co. supplied tri-n-butylphosphine. It is used as received and stored under a nitrogen gas atmosphere sealed by a syringe cap. Octacarbonyldicobalt is used as received from Morton Thiokol, Alpha Products Division, and stored in a freezer at 0°F.

General Hydroformylation Procedure:

A 300 mL stainless steel pressure reactor (Autoclave Engineers) is fitted with a pressure regulated hydrogen gas-carbon monoxide delivery system and vent with relief valve set at 1500 psig. Reaction temperature is monitored using a thermocouple held in a thermo-well, and maintained using a controller and an electrical heater. The reaction solution is agitated at 300 rpm with a turbine agitator. After flushing the opened autoclave with nitrogen gas, dodecene (84 g, 0.5 mole) and either catalyst A or B is charged. Catalyst A consisted of  $[\text{Co}(\text{CO})_2\text{PBu}_3]_2$  (8.63 g, 0.0125 mole) and tri-n-butylphosphine (0.6 mL, 0.51 g, 0.0025 mole). Catalyst B consisted of octacarbonyldicobalt (4.28 g, 0.0125 mole) and tri-n-butylphosphine (7.58 mL, 6.06 g, 0.03 mole). In both catalyst A and catalyst B, an excess of tributylphosphine kept the cobalt complexed with phosphine. The excesses are 0.0025 and 0.005 mole for catalyst A and B respectively. The autoclave is sealed and pressure checked with nitrogen gas while agitating. The head-space is charged to 1000 psig with hydrogen gas-carbon monoxide, and then vented to the atmosphere. This is repeated five times to exchange the head-space gases. The reactor contents is heated at the desired temperature until gas consumption ceased; the overall reaction is slightly exothermic. After cooling to room temperature, reactor contents are removed using a pipette.

Isolation of Tridecanol by Batch Distillation:

Distillations are done using a glass apparatus consisting of a 2-neck, pear-shaped 100 mL flask, and a 15 cm x 150 mm insulated Vigreux column connected to a distillation head which contained a cold finger condenser and pressure equalizing stopcocks for taking fractions during vacuum distillation. Nitrogen gas is slowly bled into the distillation flask through a sub-surface glass capillary tube fitted into one of the two necks. Nitrogen gas flow is adjusted so the vacuum pump could maintain pressure at 0.5 + -0.1 mm Hg. Heat is supplied with a hot air bath constructed from a mantle-heated beaker. Prior to distillation, the crude liquid product is decanted from undissolved catalyst. Distillation of the crude liquid gave paraffins and unreacted dodecenes which are collected from 26° to 85° C at 0.5 mm Hg. These foamed, but the Vigreux column broke the foam and prevented tridecanol from being carried into this fraction. The Vigreux column is removed after the paraffin-olefin fraction is collected. The fraction boiling from 95° to 140° C at 0.5 mm Hg, a water-white liquid, is collected, weighed, and labeled as tridecanol. During redistillation, a center cut is collected which boiled at 81°-83° C at 0.15 mm (Hg).

<sup>1</sup>H NMR Determination of Branching Index and Branching Methyl Groups:

Applicants select the deepest valley occurring near 1.0 ppm, most frequently at 1.1 ppm, and defined methyl protons as those appearing at higher field. Branching Index (BI) is defined as the ratio of integrals for all methyl protons to all protons expressed as a percent. The total number of methyl groups in the molecule are calculated:

$$\text{Total Methyl Groups} = [\text{BI} \cdot (n + 1)] / 150$$

where n = number of carbon atoms

For the tridecanols, n was taken as 13, and chain ends are defined as methyl and  $\text{CH}_2\text{OH}$ . Thus, the number of branching methyl groups are defined as:

$$\text{Branching Methyl Groups} = \text{Total Methyl Groups} - 1$$

Synthesis of  $[\text{Co}(\text{CO})_2\text{PBu}_3]_2$ :

This procedure follows that described by Manning and Forbus, but it contains more details and some minor improvements. See Manning, A.R., Infrared Spectra of Some Derivatives of Octacarbonyldicobalt, (A), 1135-1137 (1968); Forbus, N.P., Kinetics and Mechanisms of Substitution Reactions of Dicobalt Octacarbonyl, Ph.D. Dissertation, University of Illinois, 22-32 (1980), hereby incorporated by reference. With nitrogen gas, purge a 2-neck, 500 mL round-bottom flask fitted with a reflux condenser. While sweeping the flask with nitrogen gas, charge approximately 300 mL of dry toluene. Alternative, evacuate the flask and fill with nitrogen gas. Repeat this 5 times to remove dissolved oxygen gas. Remove the octacarbonyldicobalt from the freezer and allow to warm to room temperature. Quickly weigh in the air octacarbonyldicobalt (34.2 g, 0.1 mole) and charge to the reaction flask while purging with nitrogen gas. Using a syringe, charge tri-n-

butylphosphine [49.9 mL (40.4 g), 0.2 mole] into the reaction flask. Heat under reflux for 1 hour. Remove the toluene under reduced pressure, and collect the crude, deep-red  $[\text{Co}(\text{CO})_3\text{PBu}_3]_2$  by filtration; mp  $60^\circ - 68^\circ \text{C}$ ; mp after recrystallization from toluene  $99^\circ - 102^\circ \text{C}$  (reported mp  $109^\circ - 111^\circ \text{C}$ ). Store in a tightly sealed gas jar shielded from light.

TABLE 1

Reaction Variable Effect on Tridecanol Yield					
Reference	Temperature ( $^\circ \text{C}$ )	Pressure (psig)	RxTime (hr)	Catalyst	Yield (%)
1	140	1000	24	$[\text{Co}(\text{CO})_4]_2 + \text{PBu}_3$	24
2	140	1000	24	$[\text{Co}(\text{CO})_3\text{PBu}_3]_2$	60
3	140	200	48	$[\text{Co}(\text{CO})_4]_2 + \text{PBu}_3$	29
4	140	200	69	$[\text{Co}(\text{CO})_3\text{PBu}_3]_2$	44
5	160	600	42	$[\text{Co}(\text{CO})_3\text{PBu}_3]_2$	64a
6	160	600	42	$[\text{Co}(\text{CO})_4]_2 + \text{PBu}_3$	45
7	180	200	48	$[\text{Co}(\text{CO})_4]_2 + \text{PBu}_3$	50
8	180	200	48	$[\text{Co}(\text{CO})_3\text{PBu}_3]_2$	63
9	180	1000	24	$[\text{Co}(\text{CO})_3\text{PBu}_3]_2$	69
10	180	1000	48	$[\text{Co}(\text{CO})_4]_2 + \text{PBu}_3$	41
11	200	1000	48	$[\text{Co}(\text{CO})_3\text{PBu}_3]_2$	70
12	175-180	1000	24	$[\text{Co}(\text{CO})_4]_2 + \text{PBu}_3$	61b
Notes:					

a - minimum yield due to handling losses during distillation.

b - heated for one hour at atmospheric pressure in absence of carbon monoxide before adding  $\text{H}_2/\text{CO}$ .

TABLE 2

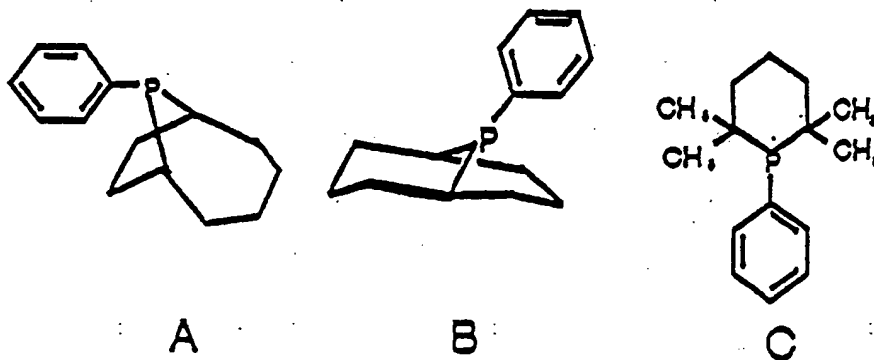
Physical and Spectroscopic Characterization of ZSM23-Tridecanol (1.4 $\text{CH}_2/\text{C}_{12}$ )	
melting range	$-56$ to $-34^\circ \text{C}$
density ( $25^\circ \text{C}$ )	0.829 g/mL
refractive index	1.4339 at $25^\circ \text{C}$
elemental analyses (a)	Calcd for $\text{C}_{13}\text{H}_{28}\text{O}$ : C, 77.93; H, 14.09; O, 7.98. Found: C, 77.63; H, 13.78
boiling point	$95-140^\circ \text{C}$ at 0.5 mm (Hg); center cut $81-83^\circ \text{C}$ at 0.15 mm (Hg)
viscosity (cSt at $40^\circ \text{C}$ )	11.59
infra-red spectrum	(neat) max, 3300 (O-H), 2900 (C-H), 1460 and 1380 (C-H bending), $1050 \text{ cm}^{-1}$ (C-O)
$^1\text{H}$ NMR spectrum	( $\text{CDCl}_3$ ) 3.62 (t, 1.8H, $J = 5.4$ Hz, $\text{CH}_2\text{CH}_2\text{OH}$ ), 2.0-1.1 (m, 18.8H, methylene and methine protons), 1.1-0.5 (m, 7.3 H, protons on methyl groups)
Note:	

a - Determined by Schwarzkopf Microanalytical Laboratories, Inc; Woodside, New York.

EXAMPLE 2Improved Yield Of Tridecanol

Above, applicants made tridecanol, a valuable surfactant intermediate, in 70% yield by hydroformylating dodecene (derived from propylene and HZSM-23 catalyst). This reaction used tributyl phosphine modified cobalt carbonyl catalyst. Here applicants describe improving the tridecanol yield using phenylphosphabicyclononane modified cobalt carbonyl catalyst. Paraffin, formed by olefin hydrogenation, is the major by-product which reduces tridecanol yield. Additionally, applicants wanted to compare alcohol yields using this same catalyst and Shell Chemical olefins, NEODENE 1112 and NEODENE 1314. These olefins are feedstocks to NEODOL 25, a commercial C<sub>2-15</sub> detergent alcohol.

Phosphine structure significantly affects hydroformylation including alcohol yield and linearity. See U.S. Patent 3,420,898; Tucci, E.R., Hydroformylating Terminal Olefins, Ind. Eng. Chem. Prod. Res. Dev., 9, 516-520 (1970); Pruett, R.L., Smith, J.A., A Low-Pressure System for Producing Normal Aldehydes by Hydroformylation of Alpha-Olefins, 34(2), 327-330 (1969), hereby incorporated by reference. Highly hindered phosphines, such as 9-phenyl-9-phosphabicyclo-[4.2.1]nonane (A), 9-phenyl-9-phosphabicyclo[3.3.1]nonane (B), and 2,2,6,6-tetramethyl-1-phenylphosphorinane (C), give least paraffin and most alcohol. Applicants chose to use phenylphosphabicyclononane, a mixture of A and B. A free radical addition of a phosphine to an olefin gives phenyl-9-phosphabicyclononane and similar phosphorus compounds. See Stiles, A.R., Rust, F.F., Vaughn, W.E., The preparation of Organo-Phosphines by the Addition of Phosphine to Unsaturated Compounds, J. Amer. Chem. Soc., 74, 3282-3284 (1952); Rauhut, M.M., Curner, H.A., Semsel, A.M., Wystrach, V.P., The Free Radical Addition of Phosphines to Unsaturated Compounds, 26, 5138-5145 (1961); U.S. Patent 3,401,204; 3,502,730, hereby incorporated by reference.



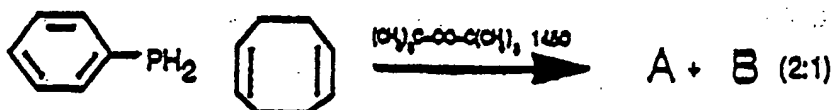
An improved hydroformylation of ZSM23-dodecene increased tridecanol yield from 70 to 89%. The ZSM23-dodecene came from oligomerizing propylene over HZSM-23 catalyst, and contained 1.3 branching methyl groups. The tridecanol yield equaled the yield from Shell's more linear, internal olefins (Table 4).



TABLE 4

Effects Of Phosphine Ligand And Temperature On Tridecanol Yields						
REACTION CONDITIONS			ALCOHOL YIELDS			
Temp °C	Phosphine	P/Co ratio	FEEDS:	NEODOL 1112	NEODOL 1314	ZSM23-C <sub>12</sub> (1.4 CH <sub>3</sub> )
180	Bu3P	1.2/1		69	69	69
180	A + B	1.2/1		88	89	80
135/160	A + B	2/1		85	-	89

A combination using mixture A and B as the cobalt catalyst ligand and a relatively low reaction temperature gave the improvement. A free radical addition of phenylphosphine to 1,5-cyclooctadiene gave the ligand, a mixture of A and B in a 2:1 ratio (67% overall yield).



Holding the hydroformylation reaction temperature at 135 °C for 2 hours followed by 160 °C for 48 hours gave ZSM23-tridecanol in 89% yield. The literature teaches that paraffin formation increases with increasing temperature and branching. See U.S. Patent Nos. 3,329,566; 3,239,569; 3,239,570. Applicants observed that double bonds isomerize more rapidly than hydroformylate. Thus, applicants assume that the three competing reactions have their activation energies ranked as follows:  
paraffin formation > hydroformylation > double bond isomerization

Using this assumption, applicants hypothesize that a very low initial temperature (135 °C) mainly isomerizes the double bond to a chain end. This likely distances the double bond from methyl branches. Also, a relatively low hydroformylation temperature (160 °C) reduces undesired paraffin formation. The data in Table 4 for ZSM23-dodecene supports this hypothesis. Interestingly, Shell's more linear, internal olefins, NEODENE 1112 and NEODENE 1314, have highest alcohol yields at 180 °C and at a 1.2:1 phosphorus to cobalt ratio. For comparison, Table 4 also contains tridecanol yields using n-tributyl phosphine as the cobalt ligand. They are inferior to the improved method.

Applicants postulate that increased steric bulk around the cobalt favors more alcohol and less paraffin. Electronic factors however, likely make a small contribution to this change. See Tolman, C.A., Steric Effects of Phosphorus Ligands in Organometallic Chemistry and Homogeneous Catalysis, 77(3), 313-348 (1977); Pruett, R.L., Smith, J.A., A Low-Pressure System for Producing normal Aldehydes by Hydroformylation of Alpha-Olefins, 34(2), 327-330 (1969), hereby incorporated by reference. Carbon monoxide insertion can occur from a 16 electron intermediate (one vacant bonding site) while an additional CO binds to the acyl-cobalt to maintain 16 valence electrons. Forming the acyl-cobalt relieves steric strain in the 18 electron intermediate by separating the phosphine ligand and olefin moiety (Figure 2). According to the literature, hydrogenation occurs by either adding hydrogen gas and forming a dihydrido intermediate (path a, Figure 3) or inserting the cobalt into another cobalt hydride (path b, Figure 3). The latter path gives a bimetallic cobalt complex. In either path, a congested 18-electron intermediate precedes paraffin formation. This increases hydrogenation activation energy relative to carbonylation, and it results in less paraffin and more alcohol.

Hydroformylation of ZSM23-dodecene gave tridecanol in 89% yield. Using 9-phenyl-9-phosphabicyclononane as the cobalt catalyst ligand and relatively low reaction temperatures increased the alcohol yield by reducing paraffin formation.

#### Hydroformylation Procedure

The general procedure is described in Example 1. Table 4 contains reaction conditions and reactant

and catalyst ratios.

### Preparation of 9-Phenyl-9-Phosphabicyclononane

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This procedure is a modification of Mason and Van Winkle's. See U.S. Patent No. 3,400,163. All glassware is dried at 120 °C and assembled hot under a purge of argon. A 250 mL, 3-neck flask is fitted with magnetic spin bar, thermometer, reflux condenser, a rubber syringe septum, argon inlet, and flowmeter. The reactor system is purged overnight with argon flowing at 3 mL/min., and then charged with redistilled 1,5-cyclooctadiene [43.3 g (49.1 mL), 0.4 mole, density = 0.882 g/mL, from Aldrich Chemical Co.] and phenylphosphine [44.0 g (44.0 mL), 0.4 mole, density = 1.00 g/mL, from Strem Chemicals] while under a stream of argon. The reaction solution is heated to 135 °C. Di-*t*-butylperoxide [1.46 g (1.8 mL), 0.01 mole, density = 0.796 g/mL, from Aldrich Chemical] is mixed with 5 mL of undecane and added with a syringe pump over 1 hour while maintaining the temperature of the exothermic reaction at 135 °-145 °C. A second portion of di-*t*-butylperoxide (1.8 mL in 5 mL of undecane) is added rapidly, and the temperature is increased to 150 °C and held for an additional hour. Periodic aliquots, taken with a syringe through the septa, are examined by infrared spectroscopy, and the disappearance of the olefin band at 1645 cm<sup>-1</sup> and the P-H band at 2300 cm<sup>-1</sup> is monitored. After two hours total reaction time, both of these bands had disappeared. The reaction mixture is distilled through a 6-inch Vigreux column and a mixture, 58.3 g (67%) of 9-phenyl-9-phosphabicyclo[4.2.1]nonane and 9-phenyl-9-phosphabicyclo[3.3.1]nonane, is collected [b.p. 123-125 at 0.1 mmHg], and stored in a refrigerated and septum-sealed flask under a nitrogen gas atmosphere. Reported b.p.: 134 °-135 °C at 0.3 mm (Hg). Gas chromatography shows the mixture is 67% 9-phenyl-9-phosphabicyclo[4.2.1]nonane (the earlier eluting isomer) and 33% 9-phenyl-9-phosphabicyclo[3.3.1]nonane.

### EXAMPLE 3

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### Esters Made From Tridecanol

Applicants synthesized bis-tridecanol esters of adipic and phthalic acid for use as plasticizers and synthetic lubricants. Applicants used two tridecanols, one with relatively low and one with a relatively high degree of methyl branching. The more linear tridecanol came from the hydroformylation of dodecene which originated from propylene using HZSM-23 discussed above. This alcohol contained 1.4 branching methyl groups. Isotridecanol came from Exxon Chemical and contained 3-4 branching methyl groups. The phthalate and adipate made from isotridecanol are Mobil lubricants.

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TABLE 3

Synthetic Lubricants: Comparison of Tridecyl Phthalates and Adipates				
	Diisotridecylphthalate <sup>(a)</sup>	Ditridecylphthalate <sup>(b)</sup>	Diisotridecyladipate <sup>(a)</sup>	Ditridecyladipate <sup>(b)</sup>
cSt 40 °C	83	43.5	26.9	21.2
cSt 100 °C	8.2	6.1	5.3	4.8
Pour Point	<37C	-54C	-65C	-37C

a - made from isotridecanol containing 3-4 branching methyl groups

b - made from tridecanol containing 1.4 branching methyl groups

A 500 mL, 3-neck round bottom flask is equipped with a magnetic stirrer, Dean-Stark water trap, and reflux condenser with a drying tube containing magnesium sulfate. The flask is charged with toluene (250 mL), phthalic anhydride (22.2 g 0.15 mole), tridecanol (60.11 g, 0.3 mole, containing 1.4 branching methyl groups), and *p*-toluene sulfonic acid (0.1 g). The reaction is heated under reflux for 20 hours. Three milliliters of water is collected. Removing the solvent under a reduced pressure gave 78.2 g (95%) of

ditridecylphthalate, a yellow liquid whose viscosity at 40° C is 43.5 centistokes.

In comparison, isotridecyl alcohol, which contains 3-4 branching methyl groups, and phthalic anhydride give a product whose viscosity at 40° C is 83 centistokes. These data show that the more linear alcohol gives a product with improved low temperature properties. Also, one skilled in the art recognizes that more linear alcohols decrease the volatility of esters such as this phthalate. These properties are useful for plasticizing PVC and other plastics. Ditridecylphthalate is also useful as a high temperature lubricant, and finds application in jet engines among other places.

A 250 mL, 3-neck round bottom flask is equipped with a magnetic spin bar, thermometer, rubber septum, nitrogen gas injector, and reflux condenser with exit port. Tridecanol (60.11 g, 0.3 mole, containing 1.4 branching methyl groups) is charged into the flask, and adipoyl chloride (27.45 g, 0.15 mole, purchased from Aldrich Chemical) is added portionwise from a syringe. A slow, continuous nitrogen gas purge swept hydrogen chloride which began to evolve after adding about half the adipoyl chloride. The reaction exothermed to 67° C. After completing the adipoyl chloride addition, the reaction mixture is maintained at 150° C for 14 hours. The yield is 73.3 g (96%) of a brown liquid. Viscosity at 40° and 100° C is 21.2 and 4.8 centistokes, respectively (viscosity index = 159).

In comparison, isotridecyl alcohol, which contains 3-4 branching methyl groups, and adipoyl chloride gave a product whose viscosity at 40° and 100° C is 26.9 and 5.3 centistokes, respectively (viscosity index = 134). Those skilled in the art generally prefer lubricants with a higher viscosity index.

Table 3 compares the viscometric and pour point data of the four esters. The more linear tridecyl esters are markedly less viscous at 40° C. This demonstrates their excellent low temperature properties, and makes them useful, for example, in maintaining PVC flexibility at ambient and sub-ambient temperatures. The highly branched esters, however, have lower pour points which makes them useful lubricants for engines subjected to very cold temperatures. Ester linearity improves the Viscosity Index (VI), especially of the adipates where VI's of the branched and linear esters are 134 and 159 respectively. Ester linearity also decreases ester volatility and extraction by detergents, two important properties for some plasticizers.

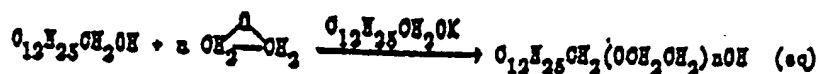
#### EXAMPLE 4

##### Preparation of Tridecanol Ethoxylates As Nonionic Surfactants

Here applicants describe making tridecanoethoxylates containing about 8-9 moles of ethylene oxide per alcohol, a level frequently used for nonionic surfactants. Tridecanol-ethoxylates and other alcohol-ethoxylates are large volume chemicals used in the growing, surfactant market.

In the presence of potassium alcoholate as catalyst, alcohols and ethylene oxide react exothermically to form alcohol-ethoxylates (equation). Although their ethylene oxide content typically reflects the original feed ratio, these ethoxylates have a molecular weight distribution. In reactions using catalytic amounts of potassium alcoholate, the relative acidities of the starting alcohol and the alcohol-ethoxylate control the distribution's width. Compared to phenols, aliphatic ethoxylates have broader distributions because the ethoxylates are more acidic than the alcohols themselves. In other words, an ethoxylating chain prefers either to grow or deprotonate another alcohol-ethoxylate rather than deprotonate a starting alcohol. This generates a mixture containing long to short-chained ethoxylates.

For alcohol-ethoxylates, hydroxyl number gives number-average molecular weight. Chromatographic methods give both weight- and number-average molecular weights. The chromatographic methods include TLC of dinitrobenzoate esters, GLPC of acetate and silyl esters, and phenylcarbamate esters. See Gildenberg, L., Trowbridge, J.R., Gas-Liquid Chromatographic Separation of Ethylene Oxide Adducts of Fatty Alcohols Via Their Acetate Esters, J. Amer. Oil Chem. Soc., 42, 69-71 (1965); Tornquist, J., Separation by Gas Chromatography of Alcohol-Ethylene Oxide Adducts, Acta Chem. Scandinavica, 20, 572-573 (1966); Allen, M.C., Lunder, D.E., Ethylene Oxide Oligomer Distribution in Nonionic Surfactants via High Performance Liquid Chromatography, J. Amer. Oil Chem. Soc., 58(10), 950-957 (1981), hereby incorporated by reference. The following describes preparation of tridecanol-ethoxylates and their analyses by hydroxyl number and GLPC of their acetate esters.



### Alcohol-Ethoxylate Syntheses.

Table 5 summarizes synthesis data on four tridecanol-ethoxylates and one mixed alcohol-ethoxylate. The tridecanols themselves had varying degrees of branching methyl groups which affect biodegradation, an important consideration for many surfactant uses. Applicants prepare and ethoxylate tridecanols containing an average of about 1 to 2.5 branching methyl groups in Example 1. Two model compounds bracketed the methyl branching of applicants' tridecanols. 1-Tridecanol is perfectly linear, and tridecyl alcohol (EXXAL 13) from Exxon Chemical has 3-4 branching methyl groups. Applicants also ethoxylate NEODOL 25 (a mixture of  $C_{12-15}$  alcohols having 1.1 methyl branches). Applicants compare the product with NEODOL 25-9, one of Shell Chemical's commercially available alcohol-ethoxylates containing nine moles of ethylene oxide. The comparison tests ability both to make and analyze alcohol-ethoxylates.

TABLE 5

Alcohol-Ethoxylate Syntheses						
ALCOHOL	REFERENCE	RxPRESS psig	RxTEMP deg C	ED Add TIME,hrs	YIELD	%PEG
NEODOL 25	1	75-90	135-140	4.5	89(a)	6(a)
	2	75	135-140	6.	93(b)	3(b)
EXXAL 13	3	85-110	135-165	3.5	95(a)	10(a)
TRIDECANOL (1.4)	4	85-110	135-150	4.25	95(a)	7(a)
	5	75	135-140	6.	95(b)	7(b)
TRIDECANOL (2.4)	6	95-110	135-150	3.75	99(a)	11(a)
TRIDECANOL-1	7	70-95	137-141	16.	74(a)	5(a)
	8	75	135-140	6.	95(b)	4(b)
Notes:						

(a) - Potassium hydroxide used as catalyst precursor.

(b) - Potassium t-butoxide used as catalyst precursor.

Potassium tridecanolate in tridecanol, generated by adding potassium hydroxide and removing the water formed, oligomerized ethylene oxide. The ethylene oxide slowly added as liquid while maintaining the pressure below 100 psig and the temperature between 135°-145° C. In three cases, applicants observe a delayed exotherm after adding all the ethylene oxide. In those instances, the temperature and pressure increased to 150°-165° C and 110 psig respectively. Operating below 90 psig (usually at 75 psig) reduced the large exotherm. Presumably, the reaction proceeded more slowly and the heat released over longer time. Isolated yields are excellent, 89-99%, excepting the ethoxylate of tridecanol-1 (74%). Here, applicants presume that ethylene oxide escapes through a leak because resynthesis gave the ethoxylate in 95%.

An extractive procedure shows that the five laboratory-prepared alcohol ethoxylates contained 5-11 wt% polyethylene glycol (PEG). In comparison, NEODOL 25-9, a typical commercial alcohol-ethoxylate, contained only 0.3 wt% PEG. Initially, applicants suspect that residual potassium hydroxide, left by an incomplete reaction of potassium hydroxide and alcohol, oligomerizes ethylene oxide making PEG. Repeating three syntheses using potassium t-butoxide, a more alcohol-soluble potassium source, reduces the average PEG content to 5% (3 trials). Although a reduction, applicants still had to find the hydroxide source which generated PEG. Water analysis shows 3700 ppm water in the tridecanol and 3855 ppm water in NEODOL 25. Assuming 600 average molecular weight for PEG, these water levels would theoretically generate 4.1 and 4.3 wt% PEG, respectively. These are close to the experimentally observed 4 and 3 wt%.

Thus, to minimize PEG content in alcohol-ethoxylates, applicants believe the alcohol must be dry.

#### Analyses of Alcohol-Ethoxylates.

Modifying Gildenberg and Trowbridge's procedure gave an improved GLPC method for determining ethylene oxide distributions on alcoholethoxylates. Id. The ethoxylates, as their acetate esters, separate by number of ethylene oxide units (rather than by alcohol isomers). The method uses a relatively short (10.5 meter) fused silica capillary column which is temperature programmed and then held at 330° C for 2.5 hours. This method routinely detected individual alcohols containing 19 ethylene oxide units (Gildenberg and Trowbridge routinely detected alcohols with 12 or fewer ethylene oxide units). Ethoxylates containing more than 19 ethylene oxide units eluted during the hold time. The instrument detected them as an undifferentiated signal above base line. Although the method's upper limit remains unknown, applicants analyze alcohol-ethoxylates containing, on average, 8-9 ethylene oxide units. Figure 4 shows GLPC's of two representative ethoxylates.

Using this GLPC method and a standard hydroxyl number determination, applicants analyze laboratory- and commercially-prepared NEODOL 25-3 and NEODOL 25-9. NEODOL 25-3 contains three moles of ethylene oxide. Table 6 contains these analyses and typical values from a Shell Chemical Company product bulletin (Table 6). Applicants believe their typical analyses uses, besides hydroxyl number, McClure's HPLC method. The number-average molecular weights (Table 6) determined by both methods differed by 2-22%. Also, samples of NEODOL 25-3 and NEODOL 25-9 have lower molecular weights and ethylene oxide content than typical values (Table 6). This likely reflects batch-to-batch variations which the NEODOL 25-9 sales specification reflects: 8.4 to 10.2 ethylene oxide units. Table 6 also shows that our laboratory-prepared NEODOL 25-9 lies between purchased and typical NEODOL 25-9 samples. This demonstrates applicants can synthesize commercial-like ethoxylates. Next, applicants apply these methods to tridecanol-ethoxylates.

TABLE 6

Analysis Of NEODOL-Ethoxylates					
	NEODOL 25-3		NEODOL 25-9		
	SHELL typical	MOBIL ANAL	SHELL typical	MOBIL ANAL	MOBIL PREP
Mw/Mn (a)	376/329	339/286	665/577	561/457	575/478
Moles EO (b)	2.9	1.9	8.5	5.8	6.3
Hydroxyl No.	167.0	180.7	92.0	97.2	91.5
Mn (c)	336	310	610	577	613
Moles EO (d)	3.0	2.4	9.2	8.5	9.3
Notes:					

(a) Determined Mw and Mn by chromatography using 203 as NEODOL 25 mol.wt.

(b) Calculated moles of EO from chromatographically determined Mn; Moles EO =  $(Mn-203)/44$ .

(c) Calculated Mn from hydroxyl number;  $Mn = 56100 \cdot OH\%$

(d) Calculated moles of EO from Mn determined by Hydroxyl Number; Moles EO =  $(Mn-203)/44$ .

Like the NEODOL-ethoxylates, the tridecanol-ethoxylates gave different molecular weights depending on the method used (Table 7). The ethoxylates of 1-tridecanol and EXXAL 13 show 12-15% differences between the GLPC and hydroxyl number methods. Both 1,4- and 2,4-methyl branched tridecanol-ethoxylates have 37-39% method-dependent differences. The reason for these latter, relatively large, differences remains unknown. Applicants believe the molecular weights determined by chromatography (in both Tables 6 and 7) are low, but applicants favor this method. It gives results which, after a correction, more consistently agree with the stoichiometry and isolated yields. However, only further analytical work will reconcile these differences.

TABLE 7

Analyses of Tridecanol-Ethoxylates				
STARTING ALCOHOL	C130H-1	(1.4 CH <sub>3</sub> )C130H <sup>(a)</sup>	(2.4 CH <sub>3</sub> )C130H <sup>(a)</sup>	EXXAL 13 <sup>(b)</sup>
ETHOXYLATE:				
Mw Mn (c)	636 520	583 469	612 496	591 495
Moles EO(d)	7.3	6.0	6.7	6.6
Hydroxyl No.	120.4	73.4	70.7	96.5
Mn (e)	466	764	793	581
Moles EO(f)	8.0	12.8	13.4	8.6
Notes:				

(a) Used 202 as average mol.wt.

(b) Used 200 as average mol.wt.

(c) Determined Mw and Mn by chromatography

(d) Calculated moles of EO from chromatographically determined Mn; Moles EO = (Mn-alcohol MW)/44.

(e) Calculated Mn from Hydroxyl Number; Mn = 56100/OH#.

(f) Calculated moles of EO from Mn determined by Hydroxyl Number; Moles EO = (Mn-alcohol MW)/44.

Tridecanols, prepared from ZSM23-oligomerized propylene, exothermically react with ethylene oxide forming tridecanol-ethoxylates. Other tridecanols, both more and less methyl-branched than the ZSM23-tridecanols, also readily ethoxylate. A GLPC method, which gives molecular weight, and ethylene oxide content of these alcohol-ethoxylates, show them comparable to a commercial standard.

#### Raw Materials.

The synthesis of tridecanol from ZSM23-dodecene is described previously in Example 1. 1-Tridecanol is purchased from Aldrich Chemical. EXXAL 13 is obtained from Exxon Chemical Co. NEODOL 25, NEODOL 25-3, and NEODOL 25-9 are obtained from Shell Chemical Co. Ethylene oxide is purchased from Matheson Gas Products. All raw materials are used as received.

#### Procedure for Ethoxylating Tridecanols.

This procedure follows those by Satkowski and Hsu, and a Shell Chemical Company Bulletin, see Ind. Eng. Chem.; Satkowski, W.B., Hsu, C.G., "Polyoxyethylation of Alcohol", 1957, 49, 1975, and describes synthesizing a tridecanol-ethoxylate containing nine ethylene oxide residues. A 500 mL autoclave is charged with tridecanol [50 g (approximately 60 mL), 0.25 mole] and potassium hydroxide (0.15 g, 0.00268 mole), and heated at 135°C under vacuum (15 mm Hg or lower) for one hour. This removes water. Nitrogen gas is added until the vessel's pressure is 45 psig. Liquid ethylene oxide [99 g (113 mL), 2.25 mole] is fed on pressure demand from a calibrated, nitrogen gas blanketed Jurgenson gauge which is fitted with a check valve. Ethylene oxide flowed once the reactor's pressure dropped below the pressure of the nitrogen gas blanket. Temperature is maintained at 135°-150°C (exothermic), and pressure kept at less than 100 psig, typically 75 psig. After all the ethylene oxide is added and the pressure approached a steady value, typically 50 psig, the cooled (<60°C) product is transferred to a nitrogen gas filled bottle that contained sufficient glacial acetic acid (0.161 g, 0.00268 mole) to exactly neutralize the potassium alkoxide catalyst. The product is not purified further, but taken as 100% active material. The product volume (approximately 150 mL) is less than the sum of the reactants because its specific gravity increased to approximately 0.98 g/mL.

Acetylation of Alcohol-Ethoxylates.

Applicants followed McClure's procedure which is summarized here. McClure, J.D., Determination of Ethylene Oxide Oligomer Distributions in Alcohol Ethoxylates by HPLC Using a Rotating Disc-Flame Ionization Detector, Presented at the AOCS Meeting, New Orleans, May 1981. Also, Shell Chemical Co. Technical Bulletin SC:580.82. The above-references are hereby incorporated by reference. An acetylation reagent is prepared by slowly adding acetic anhydride (120 mL) with stirring to a solution of p-toluene sulfonic acid monohydrate (14.4 g) and ethyl acetate (360 mL). This reagent is stored in a tightly sealed bottle shielded from light. A 100 mL flask, equipped with a magnetic spin bar and drying tube, is purged with nitrogen gas. Four grams of alcohol-ethoxylate is dissolved in 4 mL of toluene and transferred to the flask along with 12 mL of acetylation reagent. This solution is heated at 50 °C for 30 minutes, transferred to a separatory funnel along with 40 mL of toluene, and washed three times: 100 mL of 30 wt% brine; 100 mL of bicarbonate-brine (50 g sodium bicarbonate, 250 g sodium chloride, 1750 g water); 100 mL of 30 wt% brine. The toluene solution is dried (magnesium sulfate), filtered, and evaporated under reduced pressure giving acetylated alcohol-ethoxylate, a viscous liquid.

GLPC Analysis of Acetylated Alcohol-Ethoxylates.

GLPC of acetylated alcohol-ethoxylates is done on a Shimadzu GC-9A fitted with a 10.5 meter microcapillary fused-silica column coated with OV-11. Helium is the carrier gas flowing at 365 cc/min through a 10:1 pre-column splitter. Flow through the column is not measured. Initial temperature is 150 °C which is held for 3 min and then heated at 4 °C/min until reaching 330 °C where it is maintained for 152 minutes. Injection port is maintained at 300 °C, and detector is a FID. Integrations are done using a Hewlett Packard Laboratory Data System 3357. The undifferentiated signal above base line, which eluted after the ethoxylate containing 18 or 19 ethylene oxide units, is assigned 1000 MW. It is treated as a single peak for calculations. The response factor is taken as unity for all peaks.  $M_w$ 's are calculated by summing the products of molecular weight and weight fractions for each peak ( $M_w$  of the peak multiplied by its weight percent).  $M_n$ 's are calculated by summing the products of the mole fraction and the molecular weight for each peak.

Determination of PEG in Ethoxylates.

Applicants followed a Shell Chemical Company procedure which is summarized here. Ethyl acetate (50 mL), brine (50 mL containing 0.29 g sodium chloride/mL), and alcohol-ethoxylate (10 grams weighed to nearest 0.01 g) is transferred to a 250 mL separatory funnel which is stoppered, shaken for 2 min and allowed to stand for 15 minutes. All subsequent extractions followed this shake-stand procedure. The lower brine phase is transferred to a second separatory funnel. The ethyl acetate solution is extracted a second time with 50 mL of brine. The combined brine extracts are back-extracted twice with 50 mL portions of chloroform, and the chloroform layers (bottom) are filtered through a plug of cotton, are dried over anhydrous magnesium sulfate, and are evaporated to dryness in a tared (to nearest milligram) 150 mL flask. Acetone (10 mL) is added to check for the presence of sodium chloride seen as suspended crystals. If present, they are removed by filtration. The acetone is evaporated from a tared flask. The residue is dried in a vacuum oven at 50 °C and 200-300 mm Hg for one hour. After cooling to room temperature in a desiccator, the final weight of recovered PEG is taken by difference from the tared flask. The percent PEG is calculated by dividing the weight of recovered PEG by 10 (weight of original sample) and multiplying by 100.

Hydroxyl Number Determination.

The pyridine-acetic anhydride ASTM procedure is used except the acetylation time is increased from 30 to 60 minutes.

EXAMPLE 5

Comparison of Tridecanol Ethoxylate To Commercial Standards In Household And Industrial Laundry Detergents

Synthesizing tridecanol-ethoxylates from dodecenes prepared from propylene using HZSM-23 catalyst are described in Examples 1-3. These are tested as surfactants in two laundry detergents.

Detergency evaluations have evolved into systematic and miniaturized procedures. See Kissa, E., Detergency Evaluation, Detergency Theory and Technology, Marcel Dekker, Chapter 1, New York (1987), hereby incorporated by reference. Initial tests no longer require actual wash loads (although final evaluations still do). Test fabrics with uniformly applied artificial soils are commercially available. A Terg-O-Tometer, for example, washes small swatches while controlling temperature and agitation speed. This requires only one liter of test solution. Reflectance readings, taken before and after washing, measure percent soil removal. Applicants evaluate tridecanol-9 mole-ethoxylate, as a surfactant in a phosphate built industrial detergent and in a non-built household detergent. Commercial standards, C-2-11.5-alcohol-9 mole-ethoxylate and dodecylbenzenesulfonic acid sodium salt, serve as comparisons.

Detergent Types and Composition.

The industry classifies laundry detergents according to end-use market (industrial or household), physical form (liquid or powder), and builder (built or non-built). Builders are further classified as either phosphate or non-phosphate containing. From this array, applicants select two for making surfactant comparisons, an industrial liquid built with phosphates and an unbuilt household liquid. The convenience of liquid detergents (dispensing and mixing ease, and opportunity to apply detergent concentrate to spots before washing) is contributing to their rapid growth. This influences selecting two liquids. Manufacturers prefer phosphate builders, but where laws limit or ban their use, alternatives are used (usually at a performance penalty). This experiment uses a phosphate built industrial detergent to maximize soil removal, and a non-built household detergent to maximize surfactant differences.

Applicants blended three unbuilt household detergents differing only in the surfactant. Either Mobil's tridecanol-9 mole-ethoxylate, Shell's C-2-11.5-alcohol-9 mole-ethoxylate, or Vista's dodecylbenzenesulfonic acid sodium salt are used. All contain triethanolamine to make the wash liquor basic. This type formulation magnifies surfactant differences because it lacks a builder to extend the surfactant and soften hard water.

In contrast, the three industrial detergents contained a high performance builder package, and dodecylbenzenesulfonic acid sodium salt. Two of the three also contain an AE, either tridecanol-9-mole-ethoxylate or C-2-11.5-alcohol-9 mole-ethoxylate. Many commercial detergents use combinations of LABS and AE's to balance performance and cost. LABS remove particulates well and lower overall surfactant cost while AE's effectively remove oily soils. The surfactant concentrations in all three are equal (i.e., the detergent without AE had more LABS) excepting the detergent using Mobil's AE. Its concentration is not increased to offset a contaminant, 7 wt% polyethylene glycol. The builder in all three detergents contained tetrapotassium pyrophosphate, sodium metasilicate, potassium hydroxide, and carboxymethylcellulose.

Raw Materials.

Mobil's tridecanol-9 mole-ethoxylate is prepared from tridecanol having 1.4 branching methyl groups; it contains 7 wt% PEG. Shell Chemical supplied a sample of their C-2-11.5-alcohol-9 mole-ethoxylate as NEODOL 25-9. Vista Chemical supplied a 50 wt% sample of their dodecylbenzenesulfonic acid sodium salt as C-550. Hercules supplies carboxymethylcellulose as CMC 7LT. PQ supplies sodium metasilicate pentahydrate as Metso granular.

Testing Methods.

This study uses two artificial soils on three test fabrics. Carbon black in an oil matrix simulates particulate soil, and sebum/dust simulates oily soil. Test Fabrics Inc. (Middlesex, New Jersey) prints these soils on 100% cotton, 65/35 polyester/cotton with permanent press finish, and 100% polyester fabrics.

U.S. Testing Company did the fabric washing and drying under carefully controlled conditions. A Terg-O-Tometer washes using 15 minute wash time. Conditions are 100 rpm agitation speed, 130° F for the industrial detergents and 100° F for the household detergents. They made wash and rinse water to 150 ppm



hardness (U.S. national average), and washes six 3x4 inch test swatches per liter of solution. They rinse each load twice for five minutes. After washing and rinsing, the swatches are dried in an electric dryer, and ironed with a warm iron to remove wrinkles. All samples are run in triplicate.

White light reflectance, taken before and after washing, measures soil removal. A green filter cut out the effect of artificial brighteners. They measure soil redposition by taking reflectance readings of fabric margins (areas not printed with soil) before and after washing. Radio tracer methods provided a superior alternative to the reflectance technique for measuring TOTAL soil removal. See Shebs, W.T., Radioisotope Techniques in Detergency, Chapter 3, Marcel Dekker, New York (1987). However, the reflectance technique more closely measures soil removal from the fabric surface, what the consumer sees.

#### Soil Removal and Redeposition.

Tables 8 and 9 and Figures 5 and 6 summarize soil removal data. The industrial detergents clearly out-performed their household counterparts which shows the benefits of builder, surfactant combinations, and higher wash temperature. For sebum removal, the AE's are superior to LABS. For particulate removal, AE/LABS combination show a synergy and out-performed LABS itself in the industrial formulation. However, as unassisted individual surfactants (household detergents), LABS removes more particulates. These results experimentally confirm what the market place has been saying, namely, AE's are excellent surfactants especially for removing sebaceous soil. Matson, T.P., Monohydric Alcohols, Wickson, E.J., Ed., ACS Symposium Series 159, American Chemical Society, Washington, D.C., 101-112 (1981), hereby incorporated by reference.

TABLE 8

Percent Soil Removal Phosphorous Built Industrial Liquid Laundry Detergent			
SOIL AND FABRIC	SURFACTANTS		
	Mobil E + Vista LABS	Shell AE + Vista LABS	Vista LABS
Carbon Black/Oil			
Cotton	51	58	52
Polyester/Cotton	43	49	34
Polyester	48	50	29
Sebum/Dust			
Cotton	64	67	60
Polyester/Cotton	85	89	82
Polyester	57	57	39

TABLE 9

Percent Soil Removal Unbilt Household Liquid Laundry Detergent			
SOIL AND FABRIC	SURFACTANTS		
	Mobil AE	Shell AE	Vista LABS
Carbon Black Oil			
Cotton	23	24	36
Polyester Cotton	24	25	31
Polyester	22	21	40
Sebum Dust			
Cotton	48	58	36
Polyester Cotton	62	65	45
Polyester	29	29	19

Comparing Shell Chemical's C<sub>12-15</sub>-alcohol-9 mole-ethoxylate and Mobil's ZSM23-tridecanol-ethoxylate, the two surfactants are very comparable in the two laundry detergents tested. Closer examination shows that the Shell AE removed 4-7% more soil in 4 of the 12 tests. Differences greater than 3% are statistically significant. However, if concentrations are taken into account (i.e., the soil removed with the Mobil AE are increased 7%), then the Mobil AE performed equally to the Shell AE, an industry standard.

Tables 10 and 11 collect redeposition indexes (or white retention values) for the industrial and household detergents, respectively. These indexes quantitate soil removed from soiled fabric and redeposited on unsoiled fabric. A ratio of reflectances taken before and after washing unsoiled cloth gives the redeposition index. Higher values mean better performance, and readings of 98-100 are good. Values of 94-95 (or lower) show noticeable redeposition. All test specimens gave redeposition indexes of 96 or higher except one, the Shel AE. It had a redeposition index of 95 in the industrial detergent cleansing sebum dust from cotton.

TABLE 10

Soil Redeposition Index Phosphorous Built Industrial Liquid Laundry Detergent			
SOIL AND FABRIC	SURFACTANTS		
	Mobil AE + Vista LABS	Shell AE + Vista LABS	Vista LABS
Carbon Black Oil			
Cotton	99	99	97
Polyester Cotton	99	101	99
Polyester	99	100	96
Sebum Dust			
Cotton	97	95	98
Polyester Cotton	98	100	98
Polyester	98	98	96

TABLE 11

Soil Redeposition Index Unbuilt Household Liquid Laundry Detergent			
SOIL AND FABRIC	SURFACTANTS		
	Mobil AE	Shell AE	Vista LABS
Carbon Black/Oil			
Cotton	99	99	99
Polyester:Cotton	100	99	99
Polyester	99	99	99
Sebum/Dust			
Cotton	100	100	101
Polyester:Cotton	99	100	99
Polyester	99	99	98

Mobil's tridecanol-ethoxylate surfactant performed like Shell Chemical's commercial AE in both an industrial and household laundry detergent. Both effectively remove particulate and sebaceous soils from cotton, cotton-polyester blend, and polyester fabrics. In most instances both are superior to LABS.

#### EXAMPLE 6

#### Biodegradation and Ecotoxicity of Tridecanol Ethoxylates

The example concerns results of marine bacteria toxicity, results of a river die-away test with 1,4-methyl-branched tridecanol-9(EO), and microbiological conversion of tridecanols to carbon dioxide.

A marine bacteria assay, a laboratory model for fish toxicity, shows toxicity for five parent AE's — 1-tridecanol-9-mole-ethoxylate, 1,4-methyl branched tridecanol-9-mole-ethoxylate, 2,4-methyl branched-tridecanol-9-mole-ethoxylate, NEODOL-25-9, and EXXAL-13-9-mole ethoxylate. However, after an acclimated sewage inoculum biodegrades these AE's for 14 days, only the EXXAL-13-9-mole ethoxylate residue exhibits toxicity. The other residues are non-toxic to marine bacteria. The EXXAL 13 residues, on the other hand, show a slight increase in toxicity relative to the parent material. This correlates well with the GLPC analyses of the biodegraded materials. Only trace residues remain of 1,4-methyl branched-tridecanol-9(EO), 2,4-methyl branched-tridecanol-9(EO), 1-tridecanol-9(EO), and NEODOL-25. However, EXXAL 13 shows substantial residues. See Table 12.

TABLE 12

**Tridecanol Ethoxylates  
Marine Bacteria Summary**

<u>MATERIAL</u>	<u>(EC<sub>50</sub> in PPM)</u>	<u>BIODEGRADED*</u> <u>(EC<sub>50</sub> in PPM)</u>
1-Tridecanol-9(EO)	0.59	NT
NEODOL 25-9	1.90	NT
1.4-Tridecanol-9(EO)	2.91	NT
2.4-Tridecanol-9(EO)	3.30	NT
EXXAL 13-9(EO)	7.97	7.03

NT = Demonstrated no toxicity to marine bacteria.

\* = A sewage inoculum is acclimated over 3 weeks to increasing concentrations of each test material with a final acclimation concentration of 10 ppm. Each acclimated culture is then added to separate flasks containing mineral salts medium and 10 ppm of the corresponding test material. After 14 days the microorganisms are removed by centrifugation and the supernatant used in the marine bacteria assay. Values represent an EC<sub>50</sub> (concentration resulting in 50% inhibition).

In the river die-away test, 10 ppm (carbon of 1.4-methyl branched-tridecanol-9(EO)) are added to Erlenmeyer flasks containing coarsely filtered Delaware River water. The system is kept well aerated in a rotary shaker and biodegradation activity is determined by following the disappearance of dissolved organic carbon. The results of this biodegradation together with the sterile control (mercuric chloride poisoned) are presented in Figure 7. The data for the bioactive sample following a classic biodegradation curve. After a lag period, the dissolved organic carbon level is reduced from 9.3 ppm to 0.8 ppm, representing a 91% reduction in dissolved organic carbon. The sterile control shows a 36% reduction in DOC during the first 12 days of the experiment but no further reduction between 12 and 37 days. The overall results indicate that in a river environment, after a reasonable acclimation period, the potential exists for rapid and substantial biodegradation of the 1.4 tridecanol-9(EO).

Table 13 gives conversion data for tridecanols going to carbon dioxide. As expected, the unbranched 1-tridecanol demonstrated the greatest extent of conversion to CO<sub>2</sub> in 28 days (76.6%). NEODOL 25, and 1.4 methyl-branched tridecanol-9(EO) and 2.4 methyl-branched tridecanol-9(EO) show no obvious differences. These proceed at the same rate and extent with 58-60% of these slightly branched alcohols being converted to CO<sub>2</sub> in 28 days. The extensively branched EXXAL 13 demonstrates a sharply lower rate and extent (20.4%) of conversion to CO<sub>2</sub>. Naphthalene is run as a positive control with 65% being converted to CO<sub>2</sub> in 28 days. The test uses an inoculum obtained from the Mobil Technical Center and Paulsboro refinery waste treatment plants (both in New Jersey). This inoculum is acclimated to growth on the individual alcohols over several weeks.

TABLE 13

	DAYS INCUBATED				
	2	7	14	21	28
	CUMULATIVE % BIODEGRADED TO CARBON DIOXIDE				
1-Tridecanol	26.3	36.3	63.4	68.3	76.6
NEODOL 25	27.8	39.1	50.9	53.8	59.1
1.4 Methyl Branched Tridecanol	26.4	41.4	47.4	50.9	58.0
2.4 Methyl Branched Tridecanol	21.5	40.4	48.0	56.7	60.1
EXXAL 13	0	13.0	19.0	19.0	20.4
NAPHTHALENE	16.8	46.5	58.0	61.9	64.7

The EPA and OECD regulations generally assume that 60% of a growth substrate goes into energy generation (with the resultant complete oxidation of the material to CO<sub>2</sub>) and 40% of the substrate is incorporated into cellular material. Under these circumstances any CO<sub>2</sub> conversion value of 60% or greater would indicate complete metabolism of the substrate. The values for the tridecanol-9(E0) products are at or very close to this 60% mark.

Although the invention has been described in conjunction with specific embodiments, it is evident that many alternatives and variations will be apparent to those skilled in the art in light of the foregoing description. For example, the detergents can be formulated using conventional components in conventional concentrations. A formulation surfactant, can include surfactant, C<sub>12</sub> sodium alkylbenzene sulfonate, triethanol amine, ethanol, potassium chloride, optical brightener, water, dye and perfume for an unbuild heavy duty liquid detergent. A heavy duty powder detergent can include surfactant, STPP phosphate, sodium metasilicate pentahydrate, Na<sub>2</sub>SO<sub>4</sub>, Na<sub>2</sub>CO<sub>3</sub>, fumed silica and water. A hand-wash liquid can include surfactant, lauric diethanolamide, cocoamido betaine, water, brightner, perfume etc. Other formulations can be prepared by those skilled in the art. Accordingly, the invention is intended to embrace all of the alternatives and variations that fall within the intended spirit and scope of the appended claims.

### Claims

1. A process for the preparation of saturated alcohol derivatives, which process comprises:
  - (a) reacting propylene and/or a butylene over ZSM-23, as catalyst, to form an oligomer;
  - (b) hydroformylating the oligomer to form a saturated alcohol; and
  - (c) ethoxylating or esterifying the saturated alcohol.
2. A process for the preparation of an ester of the ethoxylated saturated alcohol of claim 1, which process further comprises: (d) sulphonating the ethoxylated saturated alcohol.
3. A process according to claim 1 or 2 wherein the oligomer formed in step (a) has the formula:  $(C_nH_{2n})_m$  wherein:
  - n is from 3 to 4; and
  - m is greater than 1 to 10.
4. A process according to any preceding claim wherein at least 20% by weight of the oligomer comprises an olefin having at least 12 carbon atoms.
5. A process according to any preceding claim wherein the oligomer comprises an olefin having from 0.80 to 2.0 pendant methyl groups, the olefin having no side groups other than methyl.
6. A process according to claim 5 wherein the oligomer comprises an olefin having less than 1.4 pendant methyl groups.
7. A process according to any preceding claim wherein the hydroformylation is effected with a catalyst comprising a phosphine ligand and at a temperature sufficient to promote the formulation of the alcohol while retarding formation of the paraffin.
8. A process according to any preceding claim wherein the phosphine ligand comprises tributylphosphine.
9. A process according to any preceding claim wherein the phosphine ligand comprises a substituted or

unsubstituted phenylphosphabicyclononane.

10. A process according to claim 9 wherein the phosphine ligand comprises 9-phenyl-9-phosphabicyclo[4.2.1] nonane, 9-phenyl-9-phosphabicyclo[3.3.1] nonane or a 2,2,6,6-tetramethyl-1-phenyl-phosphabicyclononane.

5 11. A process according to any preceding claim wherein the hydroformylation is effected at a temperature less than 160 °C.

12. A process according to claim 11 wherein the hydroformylation is effected at a temperature less than 135 °C.

10 13. A process according to any preceding claim wherein the saturated alcohol comprises a C<sub>3</sub> to C<sub>6</sub> alcohol.

14. A process according to claim 13 wherein the saturated alcohol comprises tridecanol.

15. A process according to any preceding claim wherein the saturated alcohol is ethoxylated with ethylene oxide with an alkali metal alkoxide as catalyst.

16. A process according to any of claims 1 to 14 wherein the saturated alcohol is esterified to form a 15 carboxylate or sulphate.

17. A process according to claim 16 wherein the ester comprises an adipate.

18. A process according to claim 17 wherein the adipate ester has a viscosity index of about 159.

19. A process according to claim 16 wherein the ester comprises a phthalate.

20. A process according to claim 19 wherein the phthalate ester has a pour point of about -54 °C.

20 21. A detergent which comprises, as surfactant, a nonionic C<sub>3</sub> to C<sub>5</sub> alcohol ethoxylate or sulphate, or an anionic C<sub>3</sub> to C<sub>6</sub> alcohol ethoxylate sulphate prepared in accordance with any preceding claim or a salt thereof.

22. A detergent according to claim 16 wherein the surfactant comprises a nonionic C<sub>3</sub> alcohol ethoxylate or sulphate, or an anionic C<sub>3</sub> alcohol ethoxylate sulphate prepared in accordance with any 25 preceding claim, or a salt thereof.

23. A lubricant which comprises an ester prepared in accordance with any of claims 16 to 18.

24. A plasticizer which comprises an ester prepared in accordance with any of claims 16, 19 and 20.

25. The use, as a surfactant, lubricant or plasticizer, of a saturated alcohol derivative wherein the saturated alcohol is prepared by reacting propylene and/or a butylene over ZSM-23 to form an oligomer; 30 and hydroformylating the oligomer.

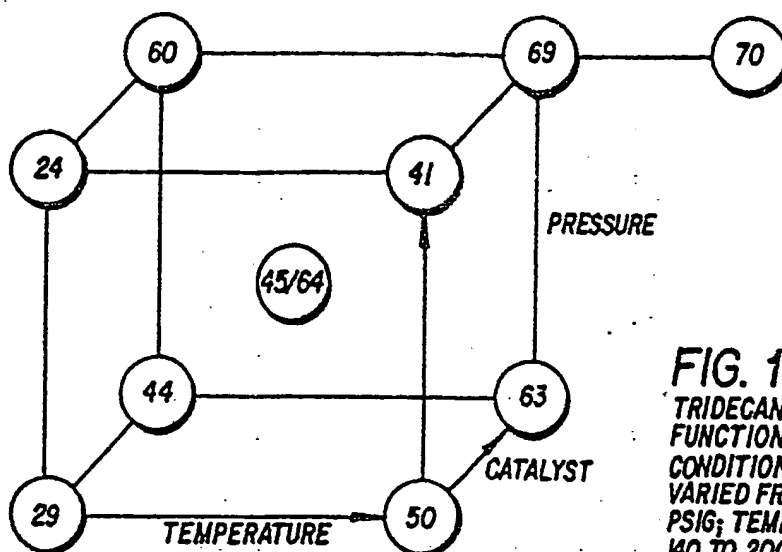
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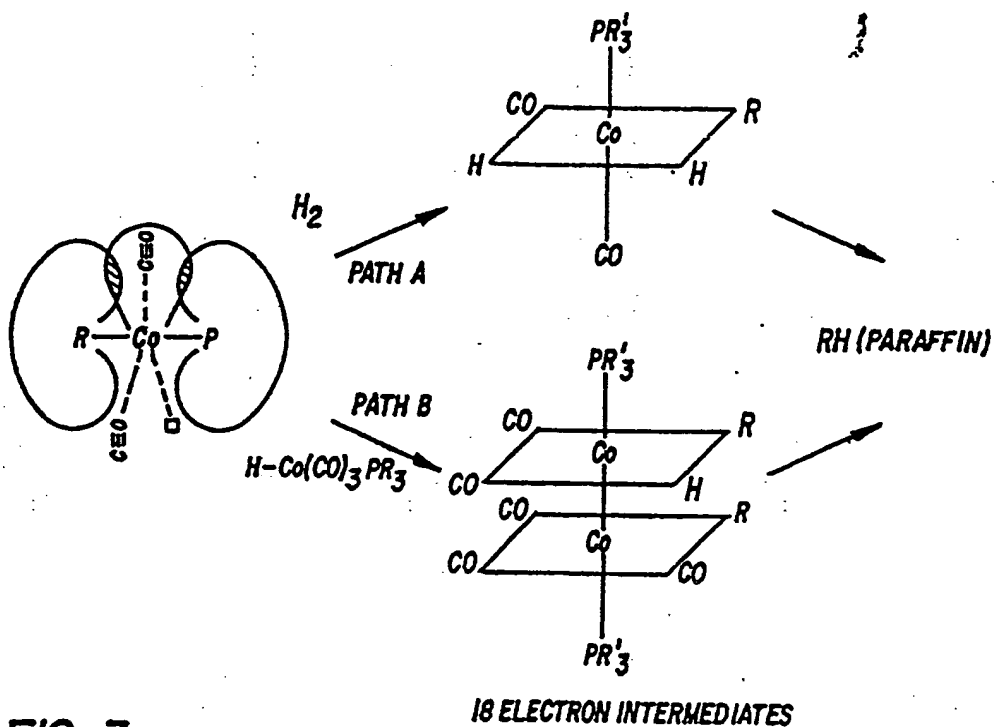
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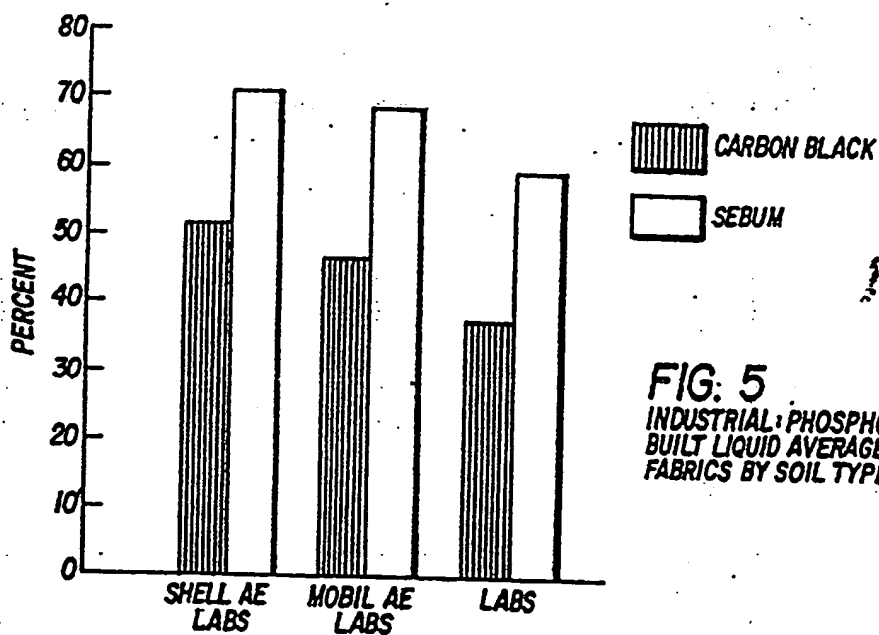
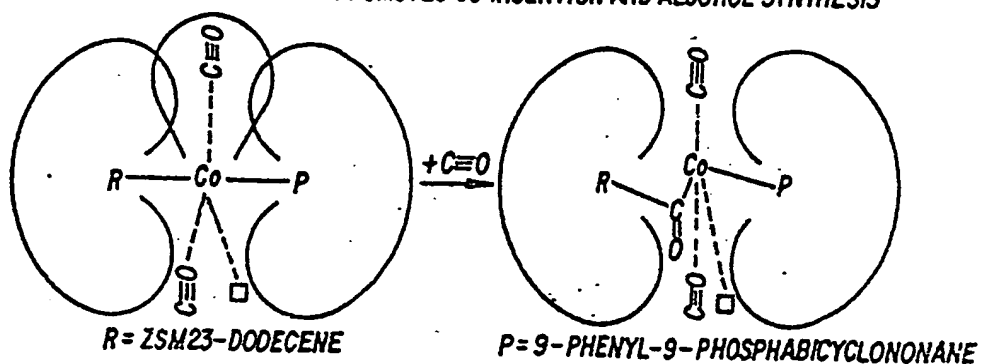
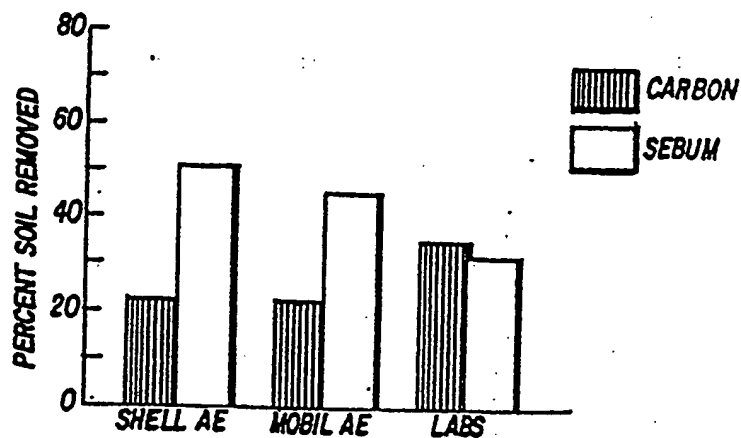
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**FIG. 1**  
TRIDECANOL YIELD AS A  
FUNCTION OF REACTION  
CONDITIONS. PRESSURE  
VARIED FROM 200 TO 1000  
PSIG; TEMPERATURE FROM  
40 TO 200°C; CATALYST WAS  
EITHER  $[\text{Co}(\text{CO})_3\text{PBu}_3]_2$  OR  
 $[\text{Co}(\text{CO})_4]_2/\text{PBu}_3$



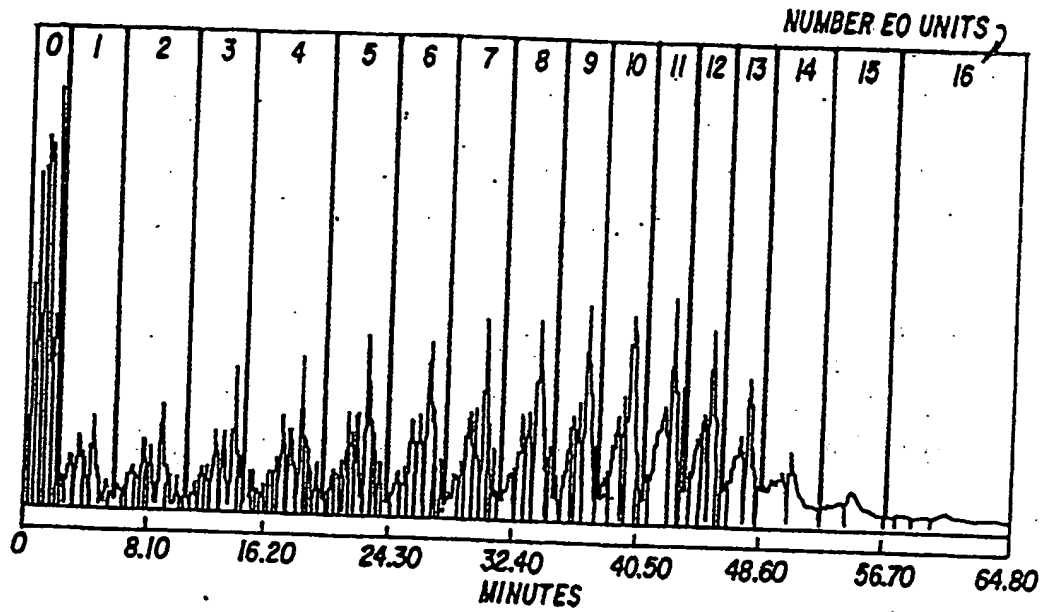
**FIG. 3**  
PARAFFIN FORMATION CAN OCCUR BY ONE OF TWO PATHS  
INVOLVING CROWDED 18 ELECTRON INTERMEDIATES

**FIG. 2** RELIEVING CROWDING PROMOTES CO INSERTION AND ALCOHOL SYNTHESIS**FIG. 5**  
INDUSTRIAL: PHOSPHOROUS  
BUILT LIQUID AVERAGE THREE  
FABRICS BY SOIL TYPE**FIG. 6**  
HOUSEHOLD: UNBUILT  
AVERAGE THREE  
FABRICS BY SOIL TYPE



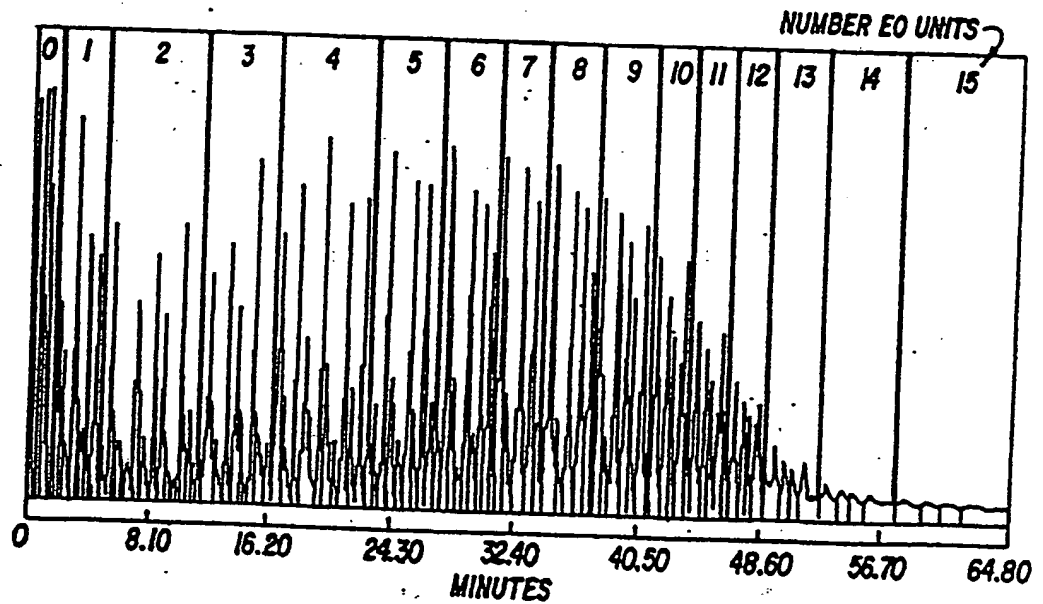
**FIG. 4A**

**1.4 METHYL BRANCHED TRIDECANOL-ETHOXYLATE**



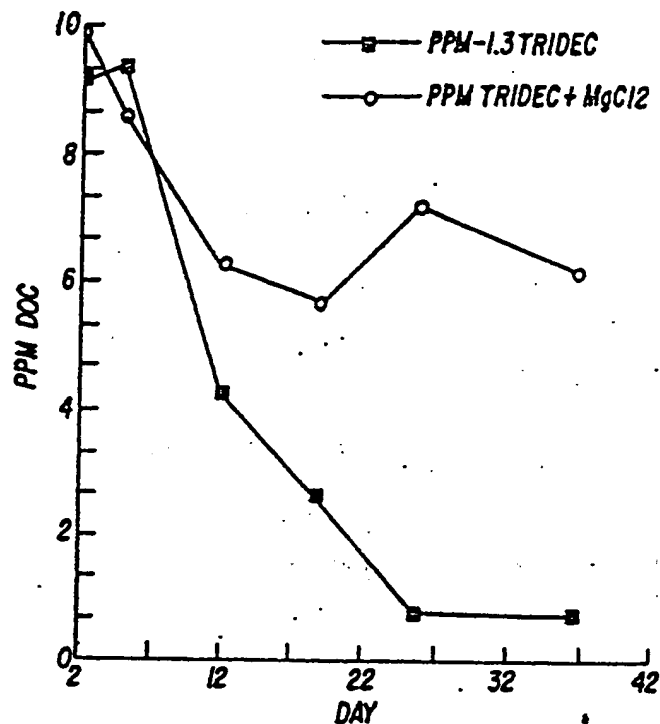
**FIG. 4B**

**NEODOL 25-9**



**FIG. 7**

RIVER DIE-AWAY-  
1,4 TRIDECANOL-  
9 MOLE ETHOXYLATE

**FIG. 8**

ABSOLUTE  
TRIDECANOL  
BIODEGRADA-  
TION

